

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.21**WELDING WITNESS REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WWR-000210**Date Inspected:** 12-May-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**Location:** Shanghai, China

Witness: **Procedure Qualification Record**
Welding **NDT**

Welder Qualification
Mechanical Testing, describe:

Fracture Critical**Index Lot #:** B71-026-007a**Witness Lot #:** B71-026-007**Bridge No:** 34-0006**Component:** Bid:52**Welder:** Zhu Haiping**ID #:** N/A**Joint Description:** B-U2a

N/A

WPS ID #: PWPS-B-T-3112

N/A

Base Metal: HPS 485W

N/A

PQR ID #: HP200781

N/A

Thickness: 75 mm

N/A

Process: SMAW

N/A

Electrode Spec/Class: AWS A5.5/E9018M-H4R

N/A

Positions: 2-F (multiple and single)

N/A

Backing Material:

N/A

CWI: Huang Wei

N/A

Average Amps: 169.8

N/A

AWS Code: D1.5 2002

N/A

Average Volts: 22

N/A

Applicable Sec: 5.10

N/A

Travel Speed: 132.7

N/A

Heat Input: 1.69 KJ/mm

N/A

Preheat: 100 Celcuis

N/A

Summary of Items Observed:

The Caltrans Quality Assurance (QA) Inspector witnessed welding of the Procedure Qualification (PQR) test plate HP200779 using shielded Metal Arc welding (SMAW), 4.0 mm diameter electrode, in the horizontal (2F)position, single pass located at one of the Tee joint side and multiple passes(3) at the other side. The welding was performed per the AWS D1.5-02, Section 5.10 fillet weld WPS qualification requirement. The welding appeared to comply with contract documents.

The QA inspector did not notice any significant air movement by testing area.

Summary of Conversations:

The QA inspector did not have any significant conversations regarding the test on this date.

Observed welding,testing or results:

is in general conformance with the contract requirements.

is not in conformance with the contract requirements.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

WELDING WITNESS REPORT

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Inspected By:	Acuna,Alfredo	Quality Assurance Inspector
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Reviewed By:	McClary,David	QA Reviewer
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